

Date: Friday, 3/24/2006 2:25:36 PM
 User: Kim Johnston

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 26345 ~1		Part Number	: D2037101	
Estimate Number	: 10145		Drawing Number	: D2037 REV C3	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/24/2006	S.O. No. : N/A	Drawing Revision	: C3	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 3/23/2006	Type : SMALL /MED FAB	Due Date	: 3/30/2006	Qty: 20 Um: Each
Previous Run	: 24160A03				
Written By	: See Agreement Below				
Checked & Approved By	: JLM 06.03.24				
Comment	: Est Rev:A New Issue 05-11-01 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M304TR0750W049	304 RD Tube .750 x .049W			
		Comment: Qty.: 4.1118 f(s)/Unit Total : 41.1180 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049) Batch: M100423(3a) / M100540 (k5)			FF 06.04.03
2.0	BRAKE NC	NC BRAKE			
		Comment: NC BRAKE			
		1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1			FF 06.04.03
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
		Comment: SMALL & MEDIUM FAB RESOURCE 1			
		1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037			FF 06.04.03
		2-Flatten ends of D2037-101 tube as required using DT8545			FF 06.04.04
		3-Deburr as required			FF 06.04.04
4.0	QC5	INSPECT WORK TO CURRENT STEP			
		Comment: INSPECT WORK TO CURRENT STEP			<i>J</i> 06.04.04
5.0	PACKAGING 1	PACKAGING RESOURCE #1			
		Comment: PACKAGING RESOURCE #1			
		Identify and Stock			
		Location: WS23			cpl 06.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/04/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Do 04/13 ⑨

Job Completion



u 06.04.13

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

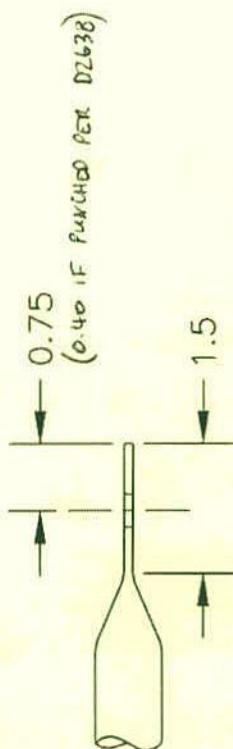
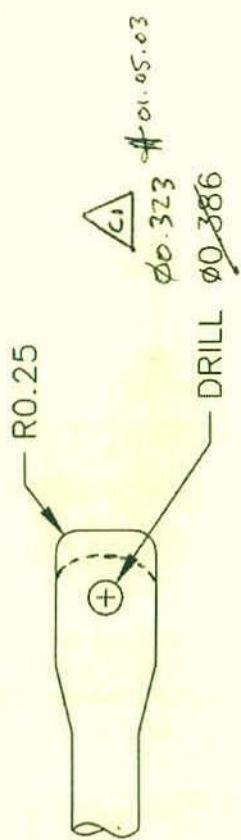
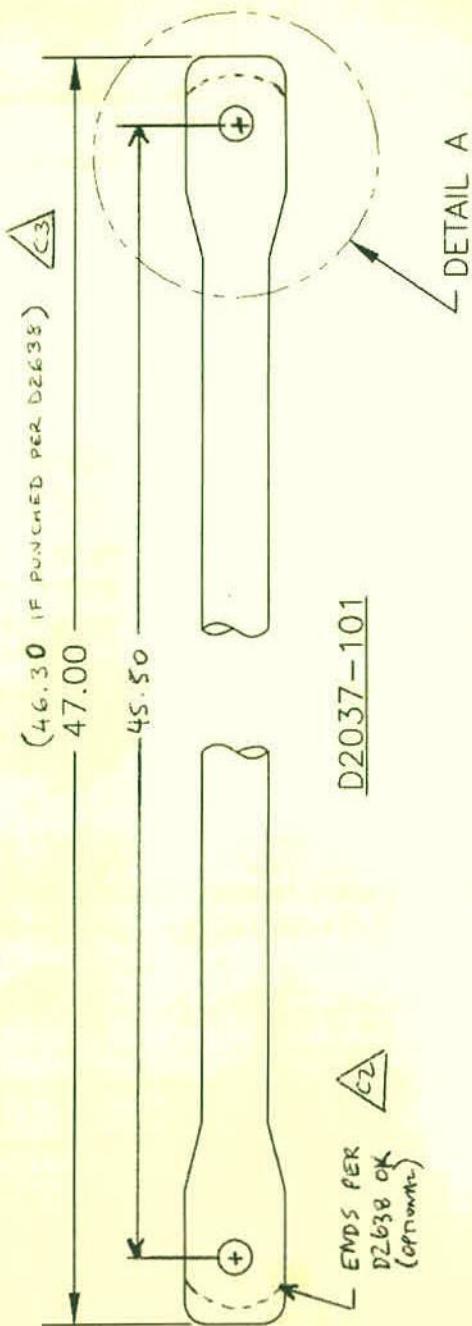
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DART



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>J</i>	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07		TITLE ARM	SCALE NTS
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1 IP	01.05.03	CHANGE TO ϕ 0.323	
C2 IP	02.06.14	ADD PUNCH PER D2638 AS OPTION	



DETAIL A

RELEASED

KE 99.06.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26345*

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 | ~~IP~~ 05.04.27 | ADD 46.30 PUNCHED PER D2638

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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